



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2877
Job Sheet 175179



Part No: D2877

Job Qty: 30 ea

Part Name: Saddle Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/28/18

Job Tracking No:

Due Date: 4/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP B 00.05.19 Added inspect level 8 EC IPP C IPP Rev:D Now M6061-T6 06-06-23 JLM IPP
Rev:E Updated Thickness as per Rev B 06-09-18 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	4/12/18	4/12/18	0.00	0.00	Start Up Waterjet		ac 18/04/03
100	Waterjet	30 pcs	4/12/18	4/12/18	0.00	1.04	Waterjet1		ac 18/04/03
120	QC	30 pcs	4/12/18	4/12/18	0.00	0.00	QC8		EB
130	HandFinish	30 pcs	4/13/18	4/13/18	0.00	0.27	HandFinish1		SA 18-04-05
140	QC	30 pcs	4/13/18	4/13/18	0.00	0.00	QC7-1		11
150	Packaging	30 pcs	4/13/18	4/13/18	0.00	0.00	Packaging3	5/01/3 SH	9-89
160	QC21-SA	30 Ea	4/13/18	4/13/18	0.00	0.00	QC21		21
Part Op Descriptions: 100 - 1-Cut as per Dwg D2884 2-Tumble ,Deburr if necessary									9-89 APR 0 6 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	1.8210 sf (.0607 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.125	2	142	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle Spacer	0.980Inches $\pm$ 0.030	1.010 0.950		
2	Saddle Spacer	0.060Inches $\pm$ 0.030	0.090 0.030	Radius	
3	Saddle Spacer	0.300Inches $\pm$ 0.030	0.330 0.270	Radius	
4	Saddle Spacer	1.000Inches $\pm$ 0.030	1.030 0.970		
5	Saddle Spacer	0.250Inches $\pm$ 0.030	0.280 0.250		
6	Saddle Spacer	0.257Inches $\pm$ 0.005	0.262 0.257	Diameter	

DQA: _____ Date: _____

ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

Date : _____

Desc _____

DART AEROSPACE
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 TEL: 1 813 832-6200
 Email: sales@dartaero.com
 www.dartaerospace.com

Container No: S057899
Part: D2877
Job No: 175179
Serial No/Batch: S057899
Revision:
Inspector:

Date: 04/04/18

AGAINST DEPARTMENT/PROCESS

Cross tube ☐

" Fab ☐

Water Jet ☐

Prod. Eng. Coord. ☐

Rec/Store/Packaging ☐

Supplier ☐

Engineering ☐

Quality ☐

Other ☐

MRB (QS1042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause

Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				

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Saddle Spacer

0.125Inches $\pm$ 0.005

0.130

thick

0.120

Plex 3/28/18 11:42 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

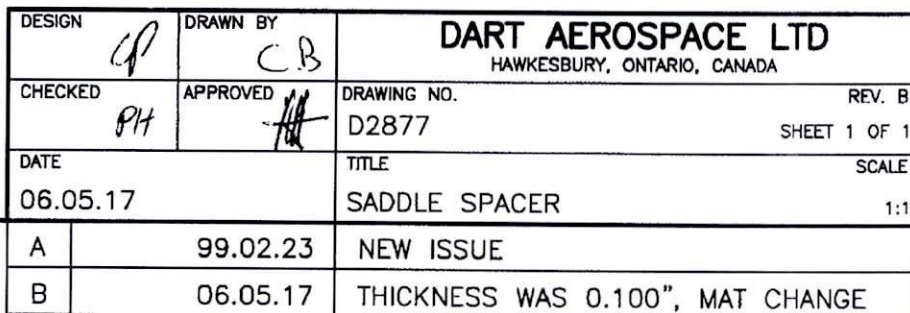


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

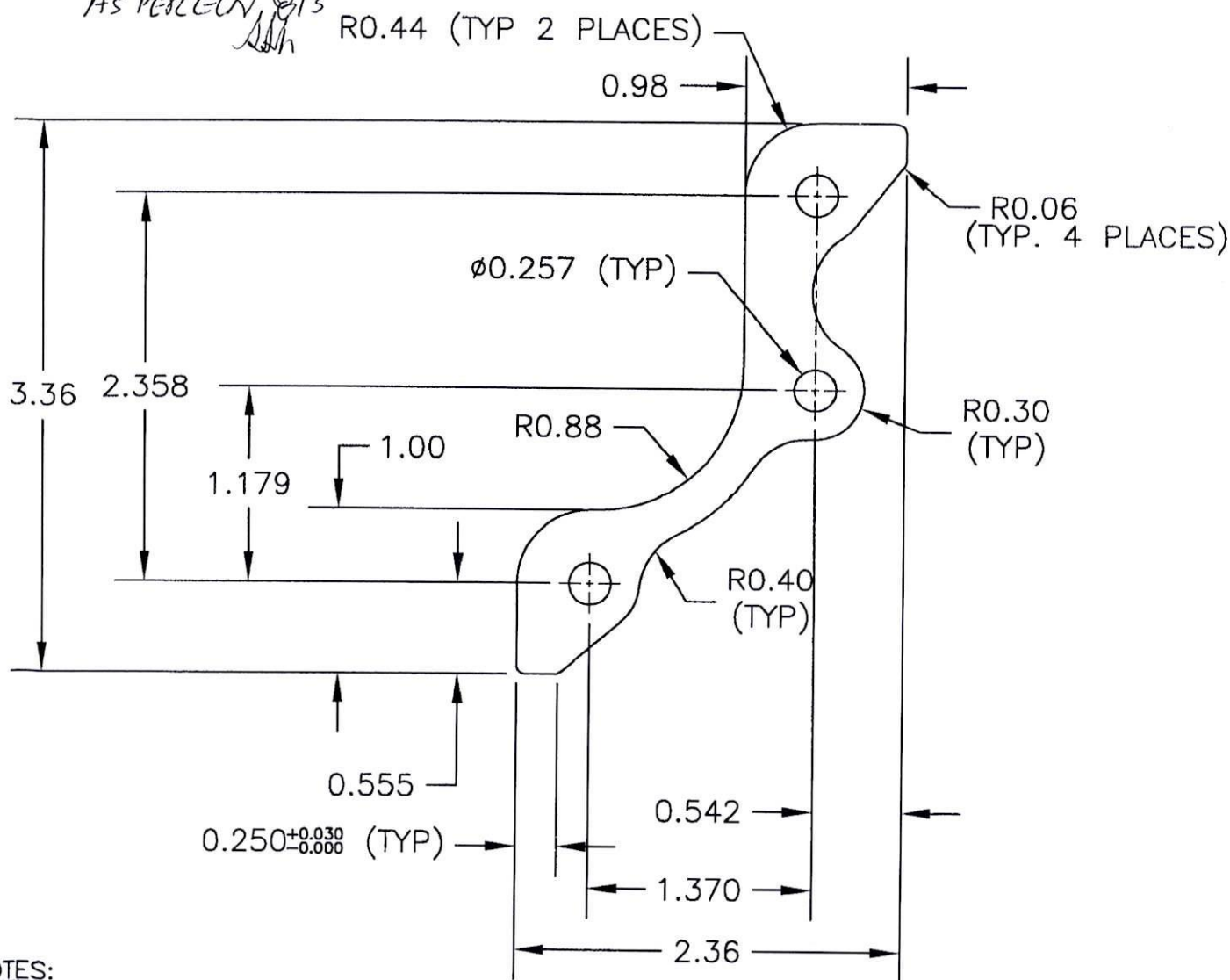
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date: _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



RELEASED
06.06.21

AS PER ECN, 813



1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK
(REF DART SPEC M6061T6S.125)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK
(REF DART SPEC M5052H32S.125)

2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) BREAK ALL SHARP EDGES 0.010 TO 0.020

5) ALL DIMENSIONS ARE IN INCHES

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